Work Order ID 115694

April-04-14 10:16:53 AM

115694

Page 1

		(V	/								
Revision ID:	D3564-11 Stainless Steel Wearplate Aft		X	Accept	*N900	040	100)*	Setup Star	Tu.	S1*
	4/04/14 Start Qty:		*12* *12*		Cust Item I Customer:	D:				- IVI	
Approvals:	Process Plan: MUS		Date: 14-04-08	Tooling:	Da	ate:			Run Star	"171	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	, *N	R2*
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D3564	Rev D										
*100 *100* Waterjet FLOW CNC Waterje 304.063*		mo ut as per	Dwg D3564 *****(D356-) 2-Deburr if necessary	0.00 0.00 4-1F)*****Dwg Rev:	<u> </u>			12	0		Jm14-04-1
110 QC	QC2- Inspect pa		achine FAI/FAIB	0.00				12		:	Jm14-04-18
Quality Control 120 *1 20* QC Quality Control	QC8- Inspect pa		ond check	0.00 DAS 27 9-59 0.00 M/4/	2)			/2			

DQA:			Date:			ŭ.							TART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:			er de				W	ork Order up	date only	
Work Orde	×:					DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS	
Part N	ю.	adi ^{do} Angelo	14.0			Rework Scrap			Skid-tube Crosstube Machining Small Fab		1	Water Jet d. Eng. Coor.	Engineering Quality
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Root					Desc	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty	1.2	or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator													
Offset/Setup Process													
Supplier Training Transport									Marie Service		1		
Unapproved				i i									
		Service					FAI	JLT CAT	TEGORY				
Landi	ng (Gear		BILL		General							
		Bending				Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced
	100	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks			121	Broken/Damage/Defect		Hardwa	ire		Part Incorred	i _	Temperature/Cure
	100	Crimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	8	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
N.	35	Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong	
		Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		Inspection	Strip in	Tube		Drawing	1 1	Misread	d				
		Marks/Ch	atter			Drill Holes		Off-set					2724
		Turning So	equence			Finish		Out of (Calibration		5		- F
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence				

Work Order ID April-04-14 10:16:53			*1156	394*				Page 2	
Item ID: D3564 Revision ID: Item Name: Stainle	4-11 ess Steel Wearplate Aft		Accept	*N900040	100*	Setup Start Stop	*N.5	31*	
Start Date: 4/04/1 Required Date: 4/04/1 Reference:	2,5	*12 *12		Cust Item ID: Customer:					
Approvals: Proc QC:	ess Plan:	Date:	Tooling: SPC (Y/N):	Date:		Run Start Stop	*NF	२1* २2*	
Sequence ID/ Work Center ID 130 *1.20* Brake NC Brake NC 140 *1.40*	Operation Description NC BRAKE Memo Deburr if nec		iuh/s	Tool ID Tool # DAS 30 9-89	Plan Accer Code Qty			Insp. Stamp	4/3
QC Quality Control 150 *150* Large Fab Large Fab	Memo Large Fab Memo Qty Dess M_12,7737	cription I Weld hardcoat as per	0.00 0.00 0.00 0.00 BatchA/R 2059B Hardcoa Dwg D3437		8	14	'-05-,	12 M	AL

DQA:			Date:			89								DAPT
<u> </u>			40-10-1				WORK ORDER NON	-C(ONFO	RMANCE /				AEROSPACE
QA Closed:			Date:	-4	U a			_	- "	max=+,=-	W	ork Order up	date only	The state of the s
Work Orde	er:					7,5	DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
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Part N	Vo.				- 2		Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
Eq.	1						Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	No.				BA		Suspected Unapproved			Large Fab	Composite		Supplier	
Root					De	escr	iption of work order update		nitial	Δ	Action	Sign &		Table 1 Mg
Cause		Date	Step	Qty			or non-conformance		ief Eng	200	scription	Date	Verification	QC Inspector
Design		14.7				E Para	1							
Doc/Data					SL.					" S. "				
Equip/Tooling			100		A									
Handling/Pre							151							
Material			1023				Te.			A Maria				
Operator	-													100
Offset/Setup								1					ł	7 3
Process				1.9	100									Takir Stan
Supplier	18													4
Training			1 335											
Transport	-				1									
Unapproved						10	И							100
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Landi		Bending				900	General Bend		Irolio/r	rogram		Outside Dim		Pressure/Forced
		Centre No	at Concor	atric			BOM/Route	H	Grain	rogram	, i.e.	Over/Under		Set-up
18 18		Cracks	or concer	TUTIC		-	Broken/Damage/Defect		Hardwa	re.		Part Incorred		Temperature/Cure
15 Per 1		Crimp/Kir	k/Rinnle	/Waxe		THE REAL PROPERTY.	Burrs	\vdash		ion Incomplete/	Unqualified	Part Lost/Mi	_	Weld
3		Cuffs	in appic	, wasc			Contamination	\vdash		tions Incomplete	_	Part Moved		Wrong Stock Pulled
	6.5	Crushing					Countersink			gned/off cente		Positioned V	_	
	100	Heat Trea	it			No.	Cut Too Short		Mislabe			Power Loss/		Other
	_	Inspection		Tube			Drawing		Misread		Says Says			
	7	Marks/Ch			3	TIES.	Drill Holes		Off-set			Jan 19		1,5
10		Turning S			T.	V. 10	Finish		A STATE OF THE PARTY OF THE PAR	Calibration		Since Senior B	400	442
16		Wave/Tw					Fit/Function		Anna Contract	Sequence				Q.V.

Work Orde		5694			*115	694*						Page 3
Revision ID:	D3564-11 Stainless Steel	Wearplate Aft			Accept	*N900	<u>040</u>	100)*	Setup Start Stop		S1*
	4/04/14	Start Qty: Req'd Qty:		*12 *12		Cust Item I Customer:	D:				Tu.	
Approvals:	Process Pla	n:		Date:	Tooling: SPC (Y/N):		ate:			Run Start Stop	1/1	R1* R2*
Sequence ID/ Work Center II)	Operation Description			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	Reject Qty	Reject Number	Insp. Stamp
*160 *160* QC Quality Control		Me	160	51004- ground weld	0.00				8	14:05	-12	DAS 9 9-89
170 *1 7 ∩ * Q€ Quality Control		QC5- Inspect pa	**************************************	ness to step on W/C	0.00				_®	14-0	2-19	DAS 9 9.
*180 *180* Powdercoat Powder Coating		Me	MO B	9:3005 4,3	0.00 0.00 OVEN TEMPERATURI	E:			8	of RI	5.6	S8

DQA:	N - 4		Date:										DART
				121		WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE				DAR
QA Closed:			Date:			AN LUC				W	ork Order up	date only	
Work Orde	r:					DISPOSITION			AGAINST	T DE	PARTMENT,	/PROCESS	
			J-KL			Rework		1	Skid-tube Crosstube]	Water Jet	Engineering
Part N	0.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
				T		Use-as-is		Thern	noforming Finishing	3	Rec/Stor	re/Packaging	Other
NCR N	lo					Suspected Unapproved			Large Fab Composite	-		Supplier	
1	HE.	12				Mari							
Root					Desci	ription of work order update		nitial	Action		Sign &		1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Cause		Date	Step	Qty	- 3	or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data		5		400									- 13
Equip/Tooling				Hill	MARINE.								TV V
Handling/Pre	-		-833						=				
Material			40.00										
Operator	-												
Offset/Setup				1773									
Process													
Supplier Training				13 H									
Transport													
Unapproved			Ka NIN										
						ONE CONTRACTOR OF CONTRACTOR O	FA	ULT CA	TEGORY	_			
Landin	ng G	ear				General	1)515						TV F Vice
	-	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
1		Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	i	Temperature/Cure
BAC)		Crimp/Kir	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong	
	I	Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	_	nspection		Tube		Drawing		Misrea	d The remaining				- 25
		Marks/Ch			1	Drill Holes		Off-set					
		Turning S				Finish			Calibration				
HE	1	Wave/Tw	ist in Tub	e	CLES TO	Fit/Function		Out of	Sequence				100

W	orl	k O	rde	· ID	11	5694
31.0	ULI					

115694

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April-04-14 10:16:53 AM *N900040100* D3564-11 Accept Setup Start Item ID: Revision ID: Stainless Steel Wearplate Aft Item Name: *12* 4/04/14 Start Qty: 12.00 Start Date: Cust Item ID: Required Date: 4/04/14 Req'd Qty: 12.00 *10* Customer: Reference: Run Process Plan: Date: Tooling: Date: Approvals: Stop OC: SPC (Y/N): Date: Date: Reject Accept Sequence ID/ Operation Set Up/AS Tool ID Tool # Plan Reject Insp. Number Stamp Work Center ID Description Code Qty Qty Run Hours - 90 QC3-Inspect Part Finish 0.00 *190* Memo Quality Control Identify as per dwg & Stock Location: 1-P-607 0.00 200 X8 of Il whosty *200* 0.00 Packaging Memo Packaging 210 QC21- Final Inspection - Work Order Release 0.00 MUD 1405-13 MV-15-13 *210* OC 0.00 Memo Quality Control

DQA:	11 50		Date:													DART
							WORK ORDER NON	-CC	ONFO	RMANCE / U	JPDATE					AEROSPACE
QA Closed:			Date:		5.24		215				Dife.	Wo	ork Order up	date only		i Ta
						No.	DISPOSITION			42.000.00	AGAINST	DEI	PARTMENT	/PROCESS		
Work Orde	_			-				1							_	
Don't N							Rework		1	Skid-tube	Crosstube	Н	D.	Water Jet	Н	Engineering
Part N	io		110		0	1	Scrap			Machining	Small Fab	Н	- 00-	d. Eng. Coor.	_	Quality
NCR N	10						Use-as-is Suspected Unapproved		inern	noforming	Finishing	-	Rec/Stol	re/Packaging	-	Other
WCK					15	1	Suspected Unapproved	J		Large Fab	Composite	Ш		Supplier		
Root	T				Des	scri	ption of work order update		nitial	A	ction		Sign &			tell of a Carry
Cause		Date	Step	Qty			or non-conformance	-10	ief Eng		cription		Date	Verification	,	QC Inspector
Design			75 E													
Doc/Data	0	1350				3										
Equip/Tooling	1		76-31													
Handling/Pre			1-60		E.			1								
Material			- 10	in a	图											
Operator		#-		M B		1										
Offset/Setup			7.53													
Process			1													
Supplier			(TI					= 14								
Training			1		かか			1								
Transport								1 5								15 A S
Unapproved		4	77.00		The second	100	7 di -									
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lin I		ending				_	Bend			Program			Outside Dim		$\overline{}$	Pressure/Forced
			t Concer	ntric			BOM/Route		Grain				Over/Under			Set-up
	(C)	racks					Broken/Damage/Defect		Hardwa			-	Part Incorre			Temperature/Cure
	1930		k/Ripple	/Wave:		_	Burrs		A CONTRACTOR OF THE PARTY OF TH	ion Incomplete/	Section Control of the Control of th		Part Lost/Mi	ssing		Weld
1	C	uffs					Contamination			tions Incomplete			Part Moved			Wrong Stock Pulled
	C	rushing				_	Countersink		Misali	gned/off center	r	-	Positioned V			
		eat Trea					Cut Too Short		Mislabe				Power Loss/	Surge		Other
	100	.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Strip in	Tube			Drawing		Misrea							
ě.		Marks/Ch			100		Drill Holes		Off-set							14
5			equence			_	Finish		-	Calibration						
[D]	V	Vave/Tw	ist in Tub	e	STEEL ST	1	Fit/Function		Out of	Sequence						

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Work Order ID: 115694

115694

Parent Item:

D3564-11

D3564-11

Parent Item Name: Stainless Steel Wearplate Aft

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-03-08 ec

IPP Rev:B

As per Rev C 07-07-09 JLM

IPP Rev:C

As per Rev D 07-09-09 JLM Verified By:EC

IPP Rev:D

Comments revised on Step 5, 6 per B44656 09-02-06 KJ

Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	A CONTRACTOR OF THE PARTY OF TH	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	197.7670	1.41	(18)			
M304S16	GA								**			. 7	m14-04

M304S16GA

304/316 Sheet .063

Location	Loc Oty	Loc Code	
MAT020	197,767		
M126915	1.487		
M127821	123.53		
M128054	33,89		
M128423	38.86		128423

DQA:			Date:			eb							DART
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:	1		Date:							W	ork Order upo	date only	
Work Orde	r:					DISPOSITION			AGAINST	DE	PARTMENT/	PROCESS	
						Rework			Skid-tube Crosstube]	Water Jet	Engineering
Part N	0.	YEL .				Scrap			Machining Small Fab		Prod	. Eng. Coor.	Quality
						Use-as-is		Thern	moforming Finishing	-	Rec/Store	e/Packaging	Other
NCR N	0.		1			Suspected Unapproved			Large Fab Composite			Supplier	
Root					Dose	ription of work order update		Initial	Action	-	Cign 9.		1 100
Cause		Date	Step	Qty	1JESC	or non-conformance	1	ief Eng	SOURCE CONTRACTOR OF THE PROPERTY OF THE PROPE		Sign & Date	Verification	QC Inspector
Design		Date	Jeep	Qty		of non-comormance	Cit	ilei Liig	Description		Date	verification	QC IIISPECTOI
Doc/Data													
Equip/Tooling			1. [2]										
Handling/Pre													12
Material				1 - 1									142
Operator			- 113	100									100
Offset/Setup					yE.				190		1		1196
Process	zi.		100	A PARTY									15:
Supplier											1		1
Training													
Transport			1110										148
Unapproved			12-13		1	5							
7. Y.							FA	ULT CA	TEGORY				The state of the s
Landir	ng G				E	General	_	1			1	_	1 J
		Bending				Bend	-		Program		Outside Dime		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	-	Grain			Over/Under to		Set-up
By .		Cracks	v 1644	NA.		Broken/Damage/Defect		Hardwa		_	Part Incorrect		Temperature/Cure
X .		Crimp/Kir	ik/Ripple,	/Wave		Burrs		111111111111111111111111111111111111111	ion Incomplete/Unqualified	L	Part Lost/Miss		Weld
		Cuffs				Contamination			tions Incomplete/Unclear	-	Part Moved		Wrong Stock Pulled
	STI.	Crushing				Countersink	-	ALCOHOLD STATE OF	gned/off center	-	Positioned Wi		Jour
	10	Heat Trea		Tuba		Cut Too Short	-	Mislabe			Power Loss/Si	urge	Other
6°		Inspection Marks/Ch		Tube.	100	Drawing Drill Holes	-	Misrea Off-set					71 1 100
la .		Turning S			TAS .	Finish	-	The state of the s	Calibration				7/3
		William Street					-				4		
		Wave/Tw	ist in Tub	e	100	Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	115694
DART AEROSPACE LID		
Description: Wearshoe	Part Number:	D3564-11
		Page 1 of 1
Inspection Dwg: D3564 Rev: D		

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.227"	==		U	Thomas
2.432	+/-0.010	2.433			U	
2.50	+/-0.030	2.50			V	
6.000	+/-0.010	6.000	·—		V	
12.104	+/-0.010	12.104	_		7	JETHU 7
18.000	+/-0.010	18-000-	-		Т	
18.00	+/-0.030	18-00"		ļ	T	
9.00	+/-0.030	9.00-	-		ν	Juniot
11.50	+/-0.030	11.500	-		V	
0.300 x 0.300	+/-0.010	0.302"x03	4" -		V	
Ø0.188	+0.005/-0.001	0-1900			V	1
R0.375	+/-0.010	0375	-		R6	
0.063	+/-0.010	0.059"	-		V	
						127.11
			7			
						1
			DAS			

Measured by: 3m	Audited by: 1949	Prototype Approval:	N/A
Date: 14-04-18	Date:	Date:	N/A

1		Data	Change	Revised by	Approved
	Rev			KJ/JLM	
-1	A	07.09.06	New Issue	KJ/EC/DD	N
Ì			Dwg Rev updated	KJIECIDD	120













